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ROTATIONAL FRICTION WELDING METHOD

Veröffentlichungsnr. (Sek.) JP6312279
Veröffentlichungsdatum : 1994-11-08
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Anmelder : MITSUBISHI HEAVY IND LTD; others: 01
Veröffentlichungsnummer : ☐ JP6312279
Aktenzeichen:
(EPIDOS-INPADOC-normiert) JP19930124993 19930428
Prioritätsaktenzeichen:
(EPIDOS-INPADOC-normiert)
Klassifikationssymbol (IPC) : B23K20/12
Klassifikationssymbol (EC) :
Korrespondierende Patentschriften

Bibliographische Daten

PURPOSE: To provide uniform penetration by rotating the parts to be welded in the mutually opposite direction, setting the center of rotation of one of the parts to be eccentric, returning the parts to be welded in a concentric manner when the prescribed friction heat is obtained, and pressing them against each other.

CONSTITUTION: Parts 1, 2 to be welded are brought into contact with each other. Chucks 3, 4 which hold the part 1, 2 to be welded are rotated by rotating device 5, 6. At the same time, an eccentrically driving mechanism 14 is driven to set the centers of the parts 1, 2 to be welded to be eccentric. As a result, the center parts of the friction surface of the parts 1, 2 to be welded are sufficiently heated, and uniform penetration can be obtained over the whole range of the friction surface. When the friction surfaces of the parts 1, 2 to be welded are sufficiently heated by the friction heat, the centers of the parts 1, 2 to be welded are put together, clutches 9, 10 are disconnected to stop the rotation, and both parts are press-joined by a pressing device 13. The oxide on the friction surface is removed.

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